D2565-207

B116927

Work Order ID 116927

April-24-14 8:39:10 AM

116927

Item ID: D2565-207 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 4/23/14 **Start Qty:** 6.00 *6*

Required Date: 4/23/14 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-04-25 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2565 / Rev E									14/06/10
100	Punch ends and deburr as per dwg	0.00							
100	NC BRAKE				DAS 30 9-89	6			
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110		0.00							
110	Small Fab					6x			14/07/04
Small Fab	**Memo**	0.00							DAS 36 9-89
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-89 14/7/4
120						6			
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D2565-207 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut

Start Date: 4/23/14 **Start Qty:** 6.00 *6*
Required Date: 4/23/14 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M128954 **Memo** START TIME: 11:00 OVEN TEMPERATURE: 400° FINISH TIME: 11:30	0.00 0.00				6 Ø	14-7-8		DAS 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				(6)			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location 81355 **Memo**	0.00 0.00				6x	14-7-8		DAS 26 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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Transport	☐									
Unapproved	☐									

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Work Order ID 116927

April-24-14 8:39:10 AM

116927

Item ID: D2565-207 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut **Stop** *NS2*

Start Date: 4/23/14 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 4/23/14 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MLS 14-07-09

14-7-8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-24-14 8:39:13 AM

Work Order ID: 116927

116927

Parent Item: D2565-207

D2565-207

Parent Item Name: Strut

Start Date: 4/23/14 **Required Date:** 4/23/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: D01.08.28Added Powder coat, and added Inspection level 3 and 21.SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	170.7591	1.7916	11.31537		DAS 30 9-89	14/06/10

M304TR0.750W.049

304 RD Tube .750 x .049W

**

Location	Loc Qty	Loc Code	
MAT017	170.7591		
122312	6		
124768	49.27		
M126183	26.0959		
M128084	89.3932		

M129188

15

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data	☐									
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☐ Other _____

DART AEROSPACE LTD

Description: Strut Work Order: 116927

Inspection Drawing: D256T Rev: E Part Number: D2565-207

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.07	+/-.030	16.07	✓		T	SS-5
15.27	+/-.030	15.27			T	SS-5

DAS

Measured by: 30 9-89

Date 14/06/10

DAS

Checked By: 36 9-89

Date 14/06/10

DAS

QC inspector: 27 9-89

Date 14/7/10

Engineering Approval (*if necessary*

Date